

Work Order ID 85051

85051

Page 1

Item ID: D206-802-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 31/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: *MLJ* Date: *12/06/01* Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D407-802-2

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-023 CHG001
12-10-31
12-10-31

12-10-18

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

12/10/19 JB

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

12-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85051***85051***

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May-31-12 3:41:41 PM

Item ID: D206-802-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 31/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPDD206-802-023

Location: 21

PPP rev: _____

10/10/31 sf

130

0.00

130

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/10/31 dg

12/10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 3:41:45 PM

Page 1

Work Order ID: 85051

85051

Parent Item: D206-802-023

D206-802-023

Parent Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3552-17		Manufactured	No			105	Each	17.0000	1	91749			
D3552-17													
Door Prop													

Location	Loc Qty	Loc Code
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ST272	15	
64338	4	
65120	1	
83585	10	
ST276	2	
69670	2	

D3622-7		Manufactured	No			105	Each	21.0000	2				
D3622-7													
Ball Stud													

Location	Loc Qty	Loc Code
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ST058	21	
64339	8	
66168	13	

D4110-3		Manufactured	No			105	Each	5.0000	1				
D4110-3													
Doubler, Sill													

Location	Loc Qty	Loc Code
----------	---------	----------

ST098	5	
64788	1	
84400	4	

84400

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 3:41:45 PM

Work Order ID: 85051

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Parent Item: D206-802-023

D206-802-023

Parent Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4111-3 Manufactured No

105 Each 4.0000

D4111-3
Sill Fitting

** 1 ✓ JB

Smb

Location Loc Qty Loc Code

ST098 4

64345 4

CR3523-4-4 Purchased No

105 Each 48.0000

CR3523-4-4
Rivet

** 2 ✓ JB

Smb

Location Loc Qty Loc Code

ST332 48

119717 48

MS20426AD4-5 Purchased No

105 Each 4,731.000

MS20426AD4-5
Rivet

** 2 ✓ JB

Smb

Location Loc Qty Loc Code

ST317 4731

6874 4731

MS20600-AD4W2 Purchased No

105 Each 209.0000

MS20600-AD4W2
Rivet

** 13 ✓ JB 12/10/17

Smb

Location Loc Qty Loc Code

ST321 209

116391 5

116471 4

116805 4

117601 1

117885 10

119638 3

120142 82

121011 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:41:45 PM

Work Order ID: 85051

85051

Parent Item: D206-802-023

D206-802-023

Parent Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21073L5

Purchased

No

105

Each

32.0000

MS21073L5

nut, plate

Smd

Location

Loc Qty

Loc Code

ST302

2

117395

2

ST303

30

120986

10

121444

20

121444

MS27039C5-11

Purchased

No

105

Each

9.0000

MS27039C5-11

Screw

Smd

Location

Loc Qty

Loc Code

ST294

9

115836

9

MS27130-A26

Purchased

No

105

Each

69.0000

MS27130-A26

Rivnut

Smd

Location

Loc Qty

Loc Code

ST293

69

116521

69

NAS1149C0563R

Purchased

No

105

Each

393.0000

NAS1149C0563R

Washer

Smd

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

193

116391

8

117460

185

117460

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Change Record

PAGE 1 OF 1

Part Number: D206-802-023

Description: HIGH VISIBILITY CREW DOOR OPENER, LH/RH

[illegible]

REFERENCE ONLY

SMB

DART AEROSPACE LTD.

IIN-D206-802-2
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5.0 PARTS LIST

5.1 D206-802-021/-022 Crew Door Opener Kits

Qty -021	Qty -022	Part Number	Description
1		D206-802-021	CREW DOOR OPENER KIT, LH
	1	D206-802-022	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4110-1	DOOR DOUBLER
	1	D4110-2	DOOR DOUBLER
1	1	D4110-3	DOUBLER, SILL
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
13	13	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT (OR A10-130)
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-023/-025 High Vis Crew Door Opener Kits

Qty -023	Qty -025	Part Number	Description
1		D206-802-023	HIGH VIS CREW DOOR OPENER KIT, LH OR RH
	1	D206-802-025	HIGH VIS CREW DOOR OPENER RETROFIT KIT
1	1	D3552-17	DOOR PROP
2	2	D3622-7	BALL STUD
1		D4110-3	DOUBLER, SILL
1	1	D4111-3	SILL FITTING
2	2	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
13		MS20600AD4W2	RIVET
1		MS21073L5	ANCHOR NUT
1	1	MS27039C5-11	SCREW
1		MS27130-A26	RIVNUT (OR A10-130)
2	2	NAS1149C0563R	WASHER

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Revision: A
Date: 10.10.13